

Date: Thursday, 2/8/2007 12:07:04 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT TUBE ASSEMBLY
Job Number	: 30695		
Estimate Number	: 10699		
P.O. Number	: N/A	Part Number	: D3391025
This Issue	: 2/8/2007	Drawing Number	: D3391 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: E
Previous Run	: 30390	Material	: N/A
		Due Date	: 3/2/2007
Written By	:	Qty:	1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev B 06-02-07 ECN773 dwg rev. D EC Est Rev: C 06-03-28 Update Manufacturing Instructions JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D6014090	ALUMINUM EXTRUSION
-----	----------	--------------------



Comment: Qty.: 1.0000 f(s)/Unit Total: 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty. Part Number Description Batch B06546

1 D6014-090 Extrusion

Identify as D3391-3

J.F. 07/02/13

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: M & Dwg D3391 Rev: E

J.F. 07/02/13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/02/13

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS

1-Machine as per Folio FA 599 Rev: M & Dwg D3391 Rev: E

2-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803



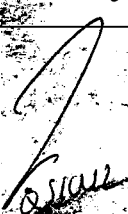
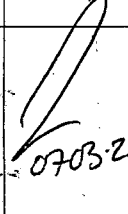
3-Deburr

J.L. 07/02/13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/06	40	Drilling of Pilot hole in aft to 3/8" from center to edge instead of 0.40"	 05/10/02	Deviation is acceptable the float bag still fit. See e-mail		 0703-20	 05/10/02	 0703-20

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 30695

Part Number: D3391025

Job Number:



Seq. #

Machine Or Operation:

Description:

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En / 3.1 07/02/15

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ME 07/02/15

7.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

DP 7-3-14

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 07-03-14

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

Pm 07-03-14

2-Drill Tube as per D3391 using DT8809 (HOLES MARKED "A" ONLY)

Pm 07-03-14

3-Drill and c' sink wearshoe holes as per Dwg D3391 Using DT8878(Mid Tube) & DT8217 Wearplate Jig

Pm 07-03-14

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391

Pm 07-03-14

5-Deburr

Pm 07-03-14

Tools: rill

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/16

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

ISL / m. 07-03-20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng		Action Description Chief Eng			

NOTE: Date & initial all entries

Date: Thursday, 2/8/2007 12:07:05 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 30695

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

POWDER COATING

POWDER COATING



m103706



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL

07/03/22

①

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m

07/03/22

②

14.0

NAS1330C3KB166

INSERT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
8	NAS1330C3KB166	Insert	m101396

m101396

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per dwg

m.l.

07/03/22

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20203.22

17.0

AEES10KB366

INSERT



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Insert

Pick:

Qty	Part Number	Description	Batch
14	AEES10KB366	Insert	m103758

m103758

18.0

AEES10KB266

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
2	AEES10KB266	Insert	m17905

or NAS1330C3KB266

m17905

FL

07/03/22 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/8/2007 12:07:05 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 30695

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AESS10KB316

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
2	AESS10KB316	Insert	<u>m17905</u>
	or NAS1330C3KB316		

20.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	<u>B30119</u>

21.0

AN3C4A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C4A	Bolt	<u>m101390</u>

22.0

AN960C10L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	<u>m103691</u>

23.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3L	Washer	<u>m103641</u>

FK

07/03/22 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 30695

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291

Sikaflex expiry date:

M 103497
07/10

FDL 07/03/23 ①

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

0703-27 ①

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

30920A

27.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07103/28 ①

Job Completion



4 070328

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng		Action Description Chief Eng			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	30695
Description: Float Skidtube (412)		Part Number:	D3391-3
Inspection Dwg: D3391	Rev: E	Page 1 of 1	

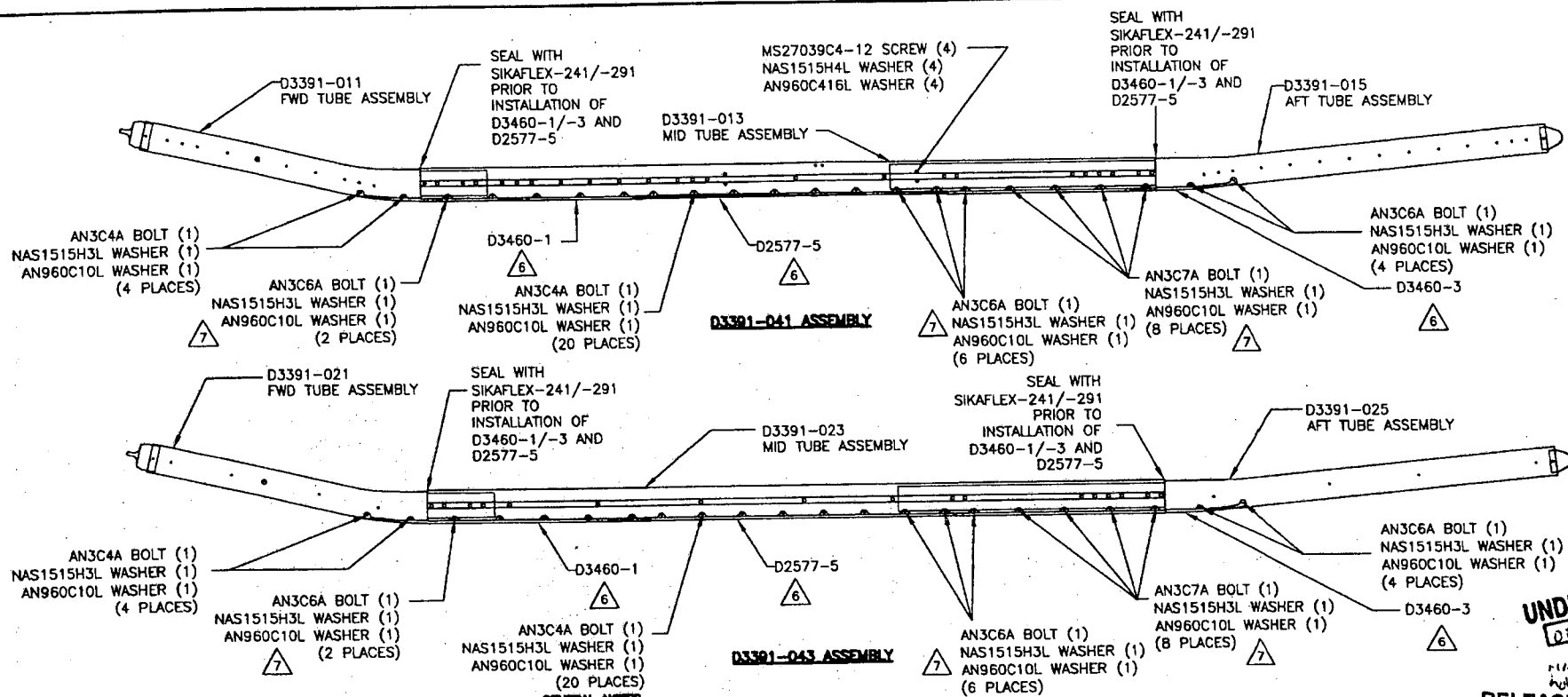
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.006	✓			
3.500	+/-0.010	3.498	✓			
88.93	+/-0.030	88.93				
44.005	+/-0.030					
3.200	+/-0.010	3.198	✓			
1.526	+0.000/-0.030	1.526	✓			
0.200	+/-0.010	0.203	✓			
7.500	+/-0.010	7.505	✓			
27.750	+/-0.010	27.750	✓		Tap	
31.750	+/-0.010	31.750	✓		Tap	
35.250	+/-0.010	35.250	✓		Tap	
0.400	+/-0.010	0.350		✓		Acceptable
Ø0.208	+0.005/-0.001	Ø0.208	✓			
3.300	+/-0.010	3.302	✓			
0.200	+/-0.010	0.203	✓			
3.520	+/-0.010	3.528	✓			
0.687	+0.010/-0.000	0.688	✓			
R0.062	+/-0.010	R0.062	✓			
Ø0.484	+0.005/-0.001	Ø0.488	✓			

Measured by: 88/SL/CA	Audited by: [Signature]	Prototype Approval:	N/A
Date: 07/02/14	Date: 07/03/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	[Signature]



UNDER REVIEW
07.02.03
07.01.15
PENDING DETAILS
holes smaller
RELEASED
06.05.03

- GENERAL NOTES**
- 1) ALL DIMENSIONS ARE IN INCHES
 - 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
 - 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL "E" SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS. C'SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.
 - 6) APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES
 - 7) DO NOT TORQUE, HAND TIGHTEN ONLY

D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

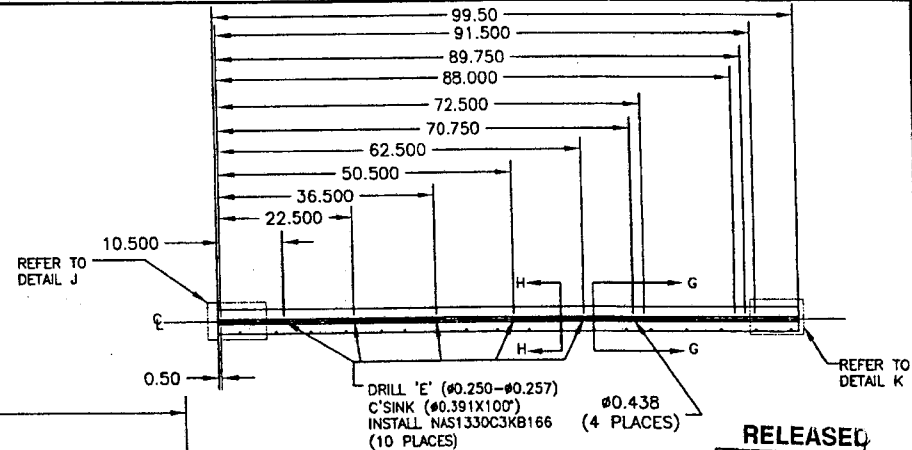
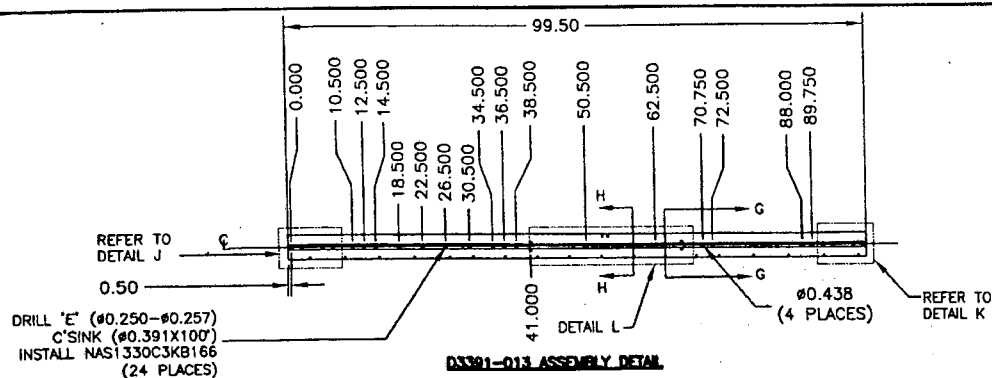
QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	NAS1515H3L	WASHER
44	44	AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
1	1	D2577-5	WEARSHOE
1	1	D3460-1	WEARSHOE
1	1	D3460-3	WEARSHOE

NO. 30695
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

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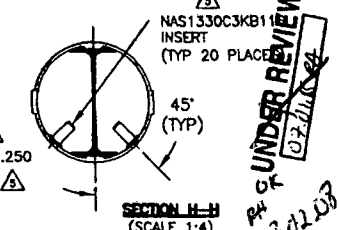
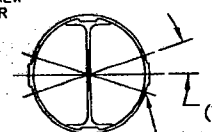
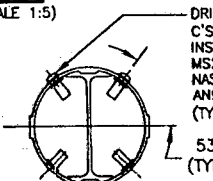
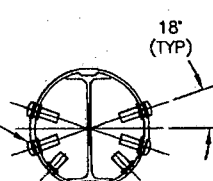
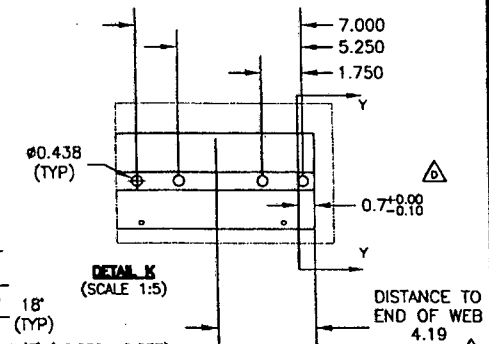
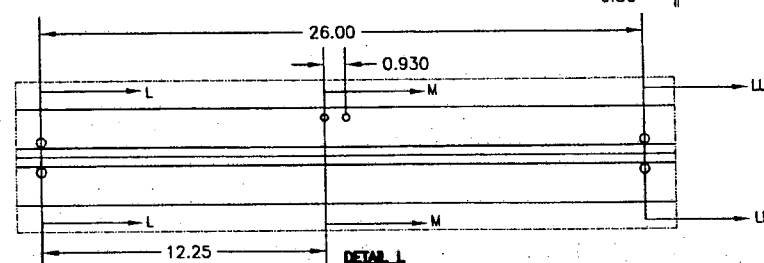
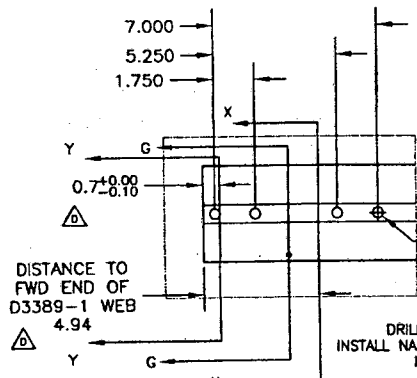
E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	06.04.25	TITLE
		D3391
		412 FLOAT SKIDTUBE

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA
REV. E
SHEET 1 OF 5
SCALE
NTS



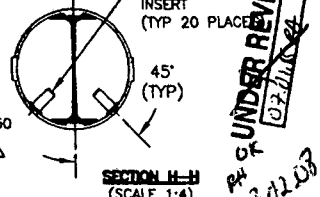
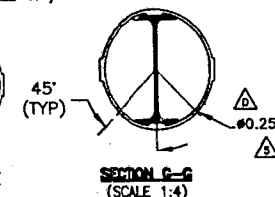
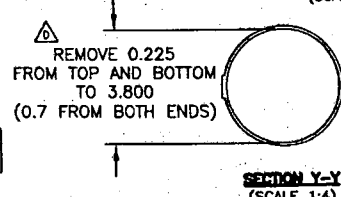
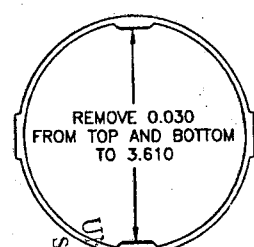
RELEASED

06.05.01



D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X		D3391-013	MID TUBE ASSEMBLY
	X	D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330C3KB116	INSERT
24	10	NAS1330C3KB166	INSERT
4		NAS1329C4KB140	INSERT
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW



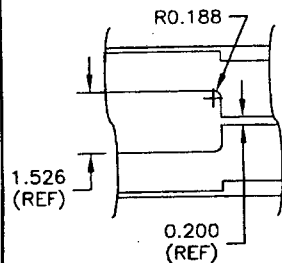
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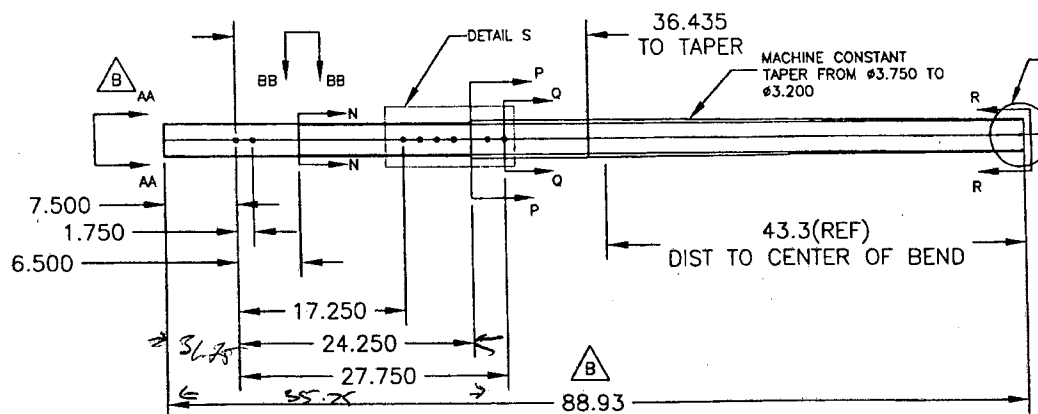
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, OH	REV. E
CHECKED #	APPROVED #		SHEET 3 OF 5
DATE 06.04.25	TITLE 412 FLOAT SKIDTUBE	SCALE 1:20	

NO. 30695
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
RETURN TO
SHOP COPY

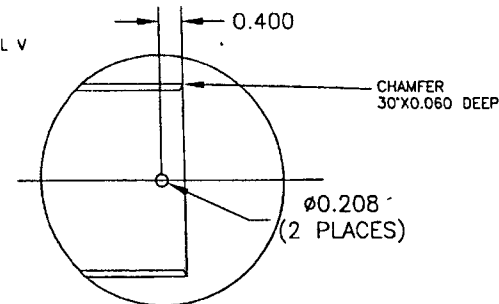
UNDER REVIEW
07/01/03



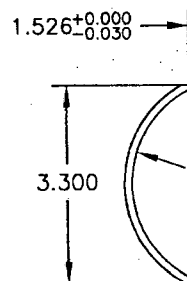
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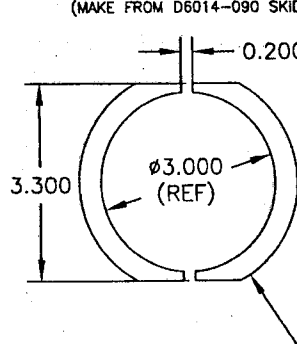
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL.)



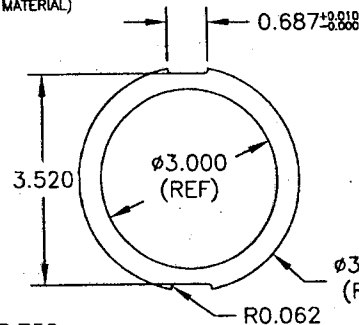
DETAIL V
(SCALE 1:2)



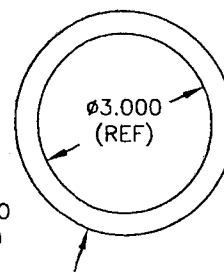
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(SCALE 1:2)



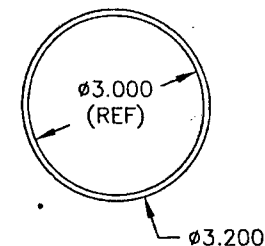
SECTION N-N
(SCALE 1:2)



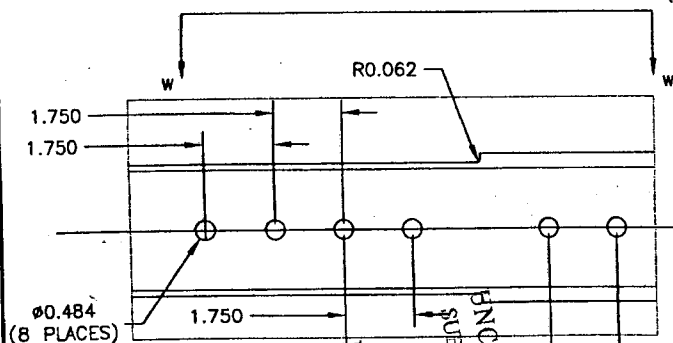
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(SCALE 1:2)



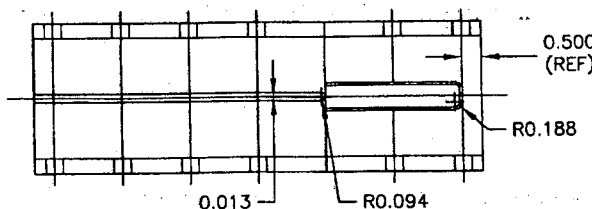
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



DETAIL S
(SCALE 1:3)



VIEW W-W
(SCALE 1:3)

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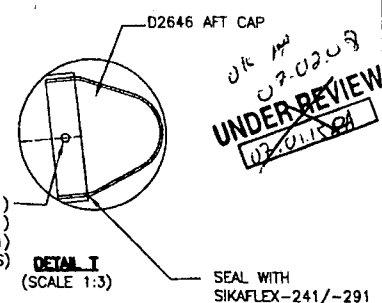
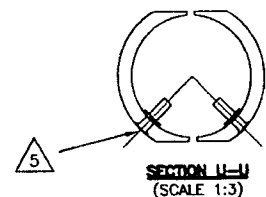
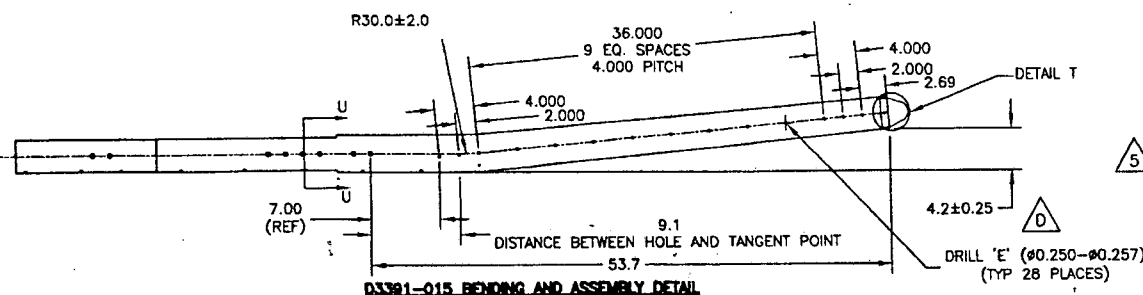
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DESIGN	PH	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, OH	REV. E
CHECKED	PH	APPROVED	PH	DRAWING NO. D3391	SHEET 4 OF 5
DATE	06.04.25	TITLE	412 FLOAT SKIDTUBE	SCALE	1:12

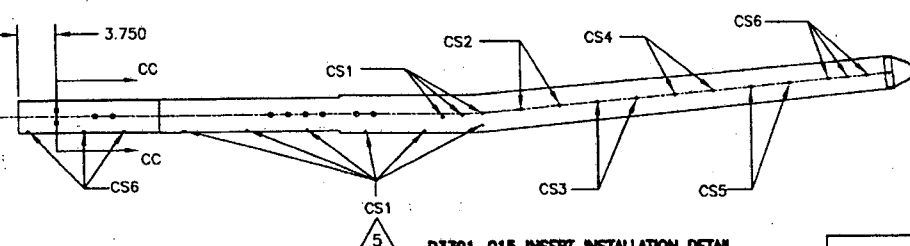
06.04.07.02.07
UNDER REVIEW
07.01.07.01
RELEASED
05.03

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WORK ORDER
30645

7.100
2.525
2.610 + .100

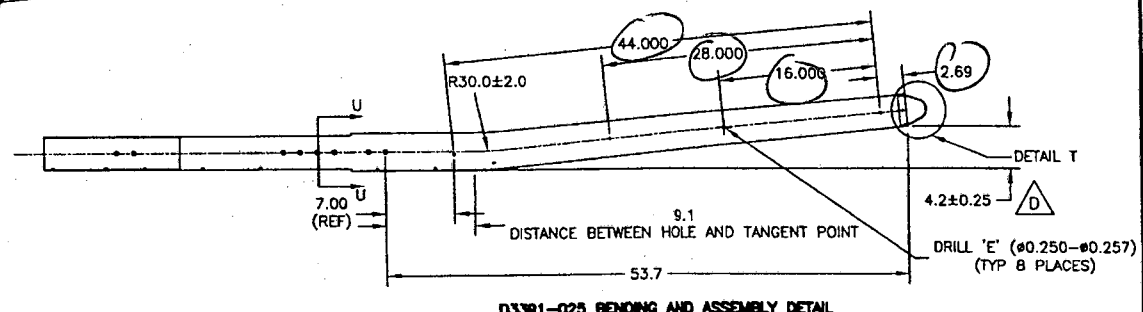


OK 12
07-02-03
UNDER REVIEW
02-01-04



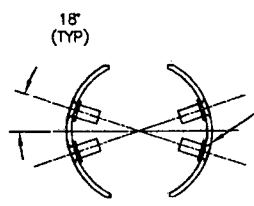
C'SINK AND INSTALL AESS10KBXXX AND/OR NAS1330C3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLE MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	AESS10KB396
CS2	2	2	Ø0.391	AESS10KB396
CS3	2	2	Ø0.391	NAS1330C3KB316
CS4	2	2	Ø0.391	NAS1330C3KB266
CS5	2	2	Ø0.391	NAS1330C3KB216
CS6	12	8	Ø0.391	NAS1330C3KB166

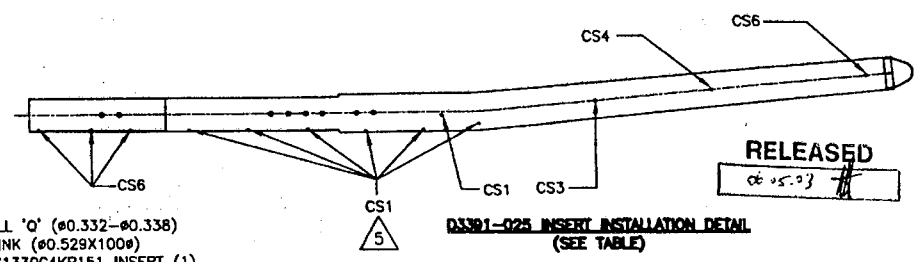


D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
18	14	AESS10KB396	INSERT
4	2	NAS1330C3KB316	INSERT
4	2	NAS1330C3KB266	INSERT
4	2	NAS1330C3KB216	INSERT
12	8	NAS1330C3KB166	INSERT
4	2	NAS1330C4KB151	INSERT
2	2	AN3C4A	BOLT
2	2	NAS1515H3L	WASHER
2	2	AN960C10L	WASHER



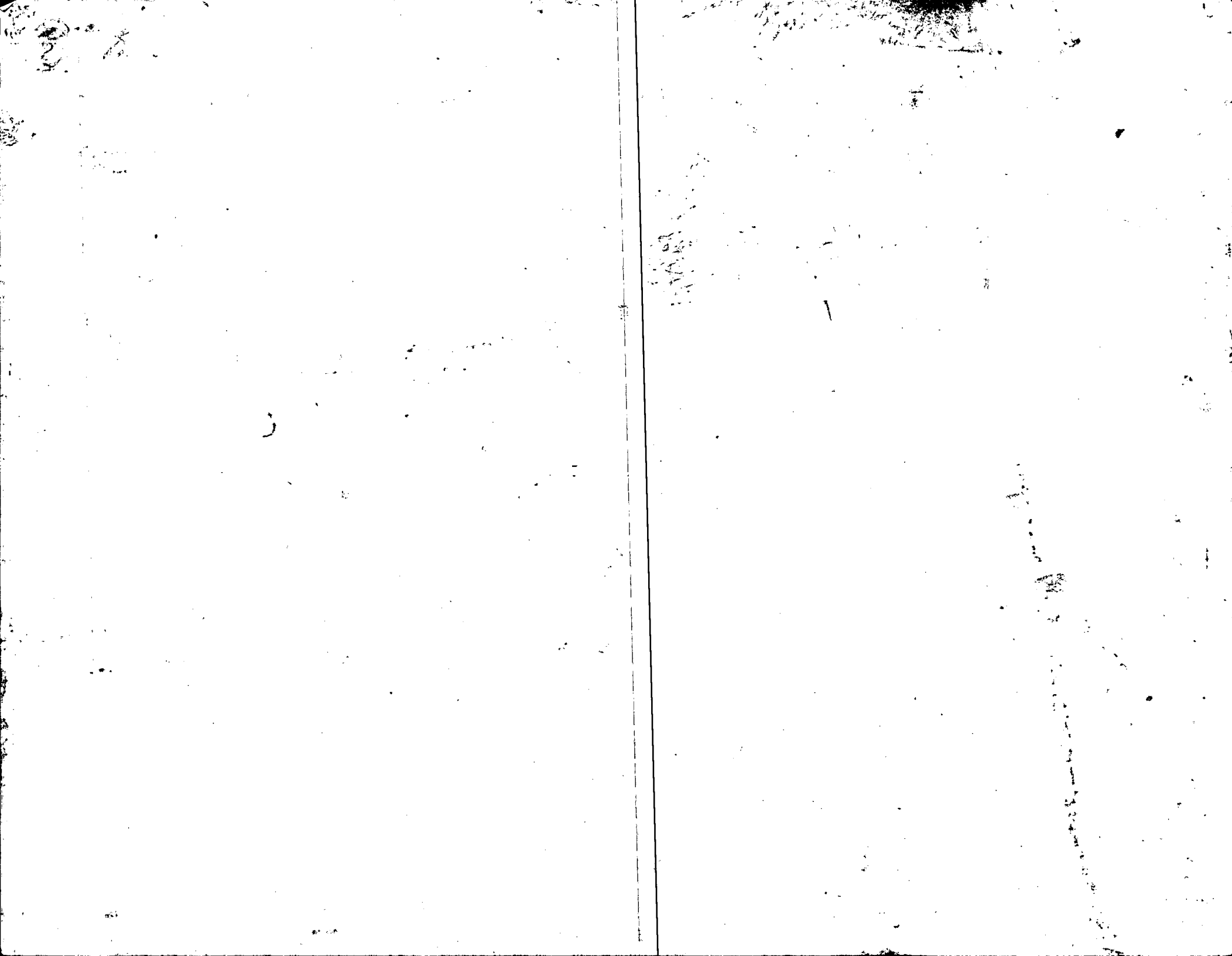
DRILL 'O' (#0.332-#0.338)
C'SINK (#0.529X100#)
NAS1330C4KB151 INSERT (1)
(4 PLACES)



RELEASED
06-05-03

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CHECKED	APPROVED	DRAWING NO. D3391		REV. E
DATE 06.04.25	TITLE 412 FLOAT SKIDTUBE		SHEET 5 OF 5	
			SCALE 1:12	

NO. 30695
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Jason Murdoch

From: David Shepherd [dshepherd@dartaero.com]
Sent: Wednesday, March 28, 2007 1:21 PM
To: 'Peter Hum'
Cc: 'Jason Murdoch'
Subject: RE: D3391 aft tube float holes off by 0.100"

Peter/Jason,

This is an acceptable deviation to me as long as the customer won't have to fight with it too hard to get the float installed.

If you feel this will not present an overwhelming challenge to a customer, then the tube is acceptable.

David

From: Peter Hum [mailto:phum@dartaero.com]
Sent: Tuesday, March 27, 2007 2:51 PM
To: 'David Shepherd'
Cc: 'Jason Murdoch'
Subject: D3391 aft tube float holes off by 0.100"

David,

Jason M was inspecting the aft tube and found the following:

- 1) The aft float bag holes are not aligned along the station lines (STA)
- 2) On one side "A" the hole is 2.58". On the other side "B" the hole is 2.69"

I've attached a sketch showing the deviation along with pictures from both sides showing that the aft float bag still fits onto the skidtube.

How should we handle this?.....Is the deviation acceptable?

Thanks
Peter

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Version: 7.1.413 / Virus Database: 268.18.18/734 - Release Date: 3/26/2007

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Version: 7.1.413 / Virus Database: 268.18.20/736 - Release Date: 3/27/2007

3/28/2007